

**Work Order ID 80187**

Monday, February 13, 2012 2:34:50 PM

**\*80187\***

A SAP

Page 1

Item ID: D3589-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: ARM GUIDE

Start Date: 2/13/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 2/16/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: *UMF*Date: *12-02-13* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00

**\*100\***

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA754 &amp; DWG D3589

FOLIO REV: *4A*DWG REV: *B*

2-DEBURR AS REQUIRED

*on 12/02/16**26*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*on 12/02/16**26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80187

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Page 2

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Accept

**\*N900040100\***

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Revision ID:

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Start Date: 2/13/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 2/16/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

h.n 12/02/16

26 0

130

Identify as per dwg & Stock Location LC

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

h.n 12/21/17 260

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

h.n 12/20/17 M.C.J 12/20/17

h.n 12-02-17 (26)

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# Picklist Print

Monday, February 13, 2012 2:34:50 PM

Page 1

Work Order ID: 80187

Parent Item: D3589-3

Parent Item Name: ARM GUIDE

Start Date: 2/13/2012

Required Date: 2/16/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC  
dwg DD verified by:EC  
iPP Rev:B 09-02-20 rev.b asper

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500 304 SS roundbar .500		Purchased	No			100	f	40.0600	0.05	1.0526316			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT029	40.06	
115334	16.56	
→ 117890	23.5	

1.36 OK 12/02/16

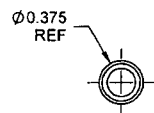
**Dart Aerospace Ltd**

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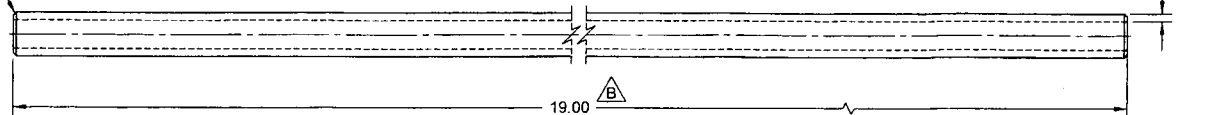
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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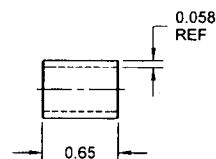
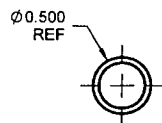
**NOTE:** Date & initial all entries



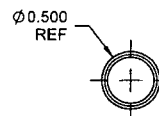
0.03 X 45°  
CHAMFER  
2 PL



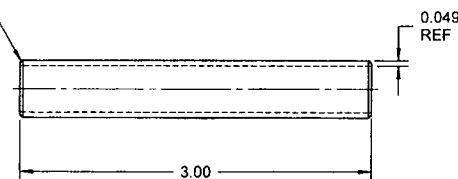
**D3589-1 ARM**



**D3589-3 ARM GUIDE**



0.03 X 45°  
CHAMFER  
2 PL



**D3589-5 LATCH GUIDE**

**D3589-1/-3/-5 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs  
- D3589-3 = 0.01 lbs  
- D3589-5 = 0.06 lbs

# 80187

**RELEASED**  
09/02/05

DESIGN	JA	<b>DART AEROSPACE LTD</b>	
DRAWN	JA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3589	SHEET 4 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	JA	LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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**Dart Aerospace Ltd**

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